

Work Order ID 164010

Tuesday, July 11, 2017 7:25:13 AM

164010

Page 1

Item ID: D412-711-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Vertical Reference Window

Start Date: 7/11/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/9/2017 Req'd Qty: 5.00

5

Customer:

Reference:

**DAS
13
9-89**

Approvals: Process Plan:

Date: **JUL 11 2017**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D412-711-101

C

110

0.00

110

Purchasing

Memo

0.00

Purchasing

ISSUE P/O:

SUPPLIER:PLAS-TECH

MANUFACTURE D412-711-101 AS PER DWG

C OF C IS REQUIRED

**DAS
13
9-89**

JLB 7/10/13

**DAS
27
9-89**

SEP 08 2017

140

Receive & Inspect for Damage & Mat'l Certs

0.00

140

Packaging

Memo

0.00

Packaging

Lex SPN-8-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Work Order ID 164010

Tuesday, July 11, 2017 7:25:13 AM

164010

Page 2

Item ID: D412-711-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Vertical Reference Window

Start Date: 7/11/2017 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 8/9/2017 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00							68-6 3E 240 AUG 30 2017
			POSITIVE RECALL EFFECTIVE JUL 11 2017 RELEASED DAS 9 9-89 DATE 17-09-26						
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							68-6 3E 240 AUG 30 2017
			DAS 27 9-89 6 SEP 08 2017						
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							17/9/8 07 DAS 21 9-89 SEP 07 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐										
Misidentified ☐	Past Due ☐	OTHER : _____									

Picklist Print

Tuesday, July 11, 2017 7:25:12 AM

Page 1

Work Order ID: 164010

164010

Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 7/11/2017

Required Date: 8/9/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL
outside process DP Verify DD

IPP Rev. B.
IPP Rev.C 17.06.20 Now

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-101P		Purchased	No				Each	0.0000					
D412-711-101P									**				
Replacement Bubble Window													

5 to
6 x SP17-8-29

MA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

W/O: 1640/2



8) VACUUM FORMING: PER FOLIO FTA077 USING DT9840 MOLD AND DART QSI 022

RELEASED
2017-02-07
EEN 17-512

C	CHG WALL DIMS PER TR-D412-711-1 REV. B	CP	16.04.21
B	REMOVED 1.75" DIM (ZN B4-1). SEE PREVIOUS REV. FOR DETAILS. 2.00 WAS 1.88 (ZN B3-1) REF CIR12-6	SFM	12.12.24
A	NEW ISSUE	MB	10.08.28
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	N/D	DRAWING NO.	REV. C
MFG. APPR.	<i>CP</i>	D412-711-101	SHEET 1 OF 1
APPROVED	<i>CP</i>	TITLE	SCALE
DE APPR.	<i>CP</i>	REPLACEMENT WINDOW	NT
DATE	16.04.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PART OF A CONFIDENTIAL JAWB IS ISSUED. ON THE EXPIRED COPYRIGHT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37037**

Purchase Order Date 7/13/2017

PO Print Date 7/19/2017

Page Number 1 of 2

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3290-3P As per dwg D3290 REV. C B164006	Window	8/3/2017 Yes 8/3/2017		8.00 Each	\$45.00	\$360.00
						Line Total:	\$360.00
2	D412-711-101P As per dwg D412-711-101 REV. C B164010	Replacement Bubble Window	8/3/2017 Yes 8/3/2017		5.00 Each	\$300.00	\$1,500.00
						Line Total:	\$1,500.00

Recu lex

SP A-8-28

*DAS
38
9-89*

Note:

7/19/2017



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 23920
Shipment Date: 08/18/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

Packing Slip

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37037
Carrier Account #

Sales Order
SO-019294

Ship Via
FREIGHTCOM INC. -

Incoterms
EX WORKS

Payment Method
COL
Tracking Number
6031136452

Item Number - Revision Description

D412-711-101 - Rev.: C REPLACEMENT WINDOW

HS Code: 3920.51.1000 - OTHER Country of Origin : CA

FREIGHT - FREIGHT

Quantity UOM
Shipped

6 EA

1 EA

SEP 17-8-28

DAS
38
9-89

Order Notes

TRYING TO SHIP LINE 2 BY FRIDAY (JULY 28)

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37037 SO # 019294

Part #	<u>D412-711-101</u>	Qty.	<u>6</u>	Batch #	<u>-002</u>
Description	<u>REPLACEMENT WINDOW</u>	Usage	<u>3 SHTS</u>	Lot#	<u>891754</u>
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	
Part #		Qty.		Batch #	
Description		Usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: AUG 18, 2017 COFC # 004
(Approved QA Signatory)

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plastechnonline.com, Web: www.plastechnonline.com

DART AEROSPACE LTD		Work Order:	
Description: F-412 - REPLACEMENT BUBBLE WINDOW		Part Number:	0412-711-101
Inspection D-412-711-101		Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: MOH

Date: Aug-14-2017

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	+/- 0.50"	14.34	✓			
2.00"	MIN	2.07	✓			
1.5"	MIN	1.07	✓			
0.076"@5"	MIN	0.096	✓			
0.063"@8"	MIN	0.086	✓			
0.046" TOP	MIN	0.054	✓			

Measured by: MOH DAS

Date: Aug-14-2017

Audited by: 38 9-89

Date: AUG 30 2017

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number:	D412-711-101
Inspection D-412-711-101 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: D. Heger

Date: 17/08/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	± 0.50"	14.8"	✓			
2.00"	MIN	2.1"	✓			
1.5"	MIN	1.6"	✓			
0.076" @ 5"	MIN	0.105"	✓			
0.065" @ 8"	MIN	0.093"	✓			
0.046" TOP	MIN	0.057"	✓			

Measured by: D. Heger

Date: 17/08/09

Audited by: 38

Date: 17/08/09

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number:	D412-711-101
Inspection D-412-711-101		Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<i>D. Lopez</i>	Date:	17/08/09
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	+/- 0.50"	14.8"	✓			
2.00"	MIN	2.02"	✓			
1.5"	MIN	1.6"	✓			
0.076"@5"	MIN	0.115"	✓			
0.063"@8"	MIN	0.098"	✓			
0.046" TOP	MIN	0.059"	✓			

Measured by:	<i>D. Lopez</i>	Date:	17/08/09
Audited by:	38	Date:	AUG 20 2009
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number:	D412-711-101
Inspection D-412-711-101 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: D. Leger

Date: 17/08/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	± 0.50"	14.8"	✓			
2.00"	MIN	2.09"	✓			
1.5"	MIN	1.6"	✓			
0.076" @ 5"	MIN	0.100"	✓			
0.063" @ 8"	MIN	0.086"	✓			
0.046" TOP	MIN	0.056"	✓			

Measured by: D. Leger

Date: 17/08/19

Audited by: DAS

Date: AUG 30 2017

Preliminary Approval: 9-89

Date:

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number:	0412-711-101
Inspection: D-412-711-101		Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: D. Lopez

Date: 17/09/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	± 0.50"	14.8"	✓			
2.00"	MIN	2.06"	✓			
1.5"	MIN	1.53"	✓			
0.076"@5"	MIN	0.084"	✓			
0.063"@8"	MIN	0.074"	✓			
0.046" TOP	MIN	0.054"	✓			

Measured by: D. Lopez

Date: 17/08/09

Audited by: DAE 38

Date: AUG 30 2017

Preliminary Approval: DAE 38

Date:

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number:	D412-711-101
Inspection D-412-711-101		Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: MOH

Date: Aug-14-2017

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	± 0.50"	14 3/4				
2.00"	MIN	7.07				
1.5"	MIN	1.06				
0.076" @ 5"	MIN	0.088				
0.063" @ 8"	MIN	0.077				
0.046" Top	MIN	0.055				

Measured by: MOH

Date: Aug-14-2017

Audited by: DAS
38
9-89

Date: AUG 30 2017

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
						1	204-030-853-125	LH COPILOT DOOR (204-030-853-137/-155)
1							D412-711-111	WIRING HARNESS, 212/412
^B 1							^B D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	^B 1						^B D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		^B 1					^B EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			^B 1				^B EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				^B 1			^B D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

- (A) IF CUSTOMER PREFERS TO SUPPLY AND MODIFY THEIR OWN DOOR, D412-711-021 SHOULD BE SUPPLIED IN LIEU OF D412-711-041
(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

NOTES

1) WIRING HARNESSES:

For Bell 204/205/210 Wiring Harnesses, use drawing D2046904.

For Bell 212 Wiring Harnesses, use drawing D2046903*.

For Bell 214 Wiring Harnesses, use drawing D214-761-511.

For Bell 412 Wiring Harnesses, use drawing D412-711-901.

For Bell 212 modified per SH07-28/SR02831NY use D212-761-224 or D212-761-225 depending on aircraft s/n.

* Despite the note on the drawing, D2046903 is applicable to all 212 aircraft serial numbers

Wiring Harnesses will vary depending on aircraft s/n.

2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

4) It is acceptable to use MS21042L3 nuts to install the window in lieu of anchor nuts shown on D2046901.

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR	NTS
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